



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3311

Job Sheet 194914



Part No: 646.3311

Job Qty: 24 pcs

Part Name: RH Half - Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/10/19

Job Tracking No:

Due Date: 6/24/19 *or sooner*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/27 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 4 Axis	24 pcs	6/24/19	0.59 31.58			HAAS - 1		<i>DJP 11-08-01</i>
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 2	24 pcs	6/24/19	0.00 0.00			QC 2 - 1		<i>DAS 73 11-08-01 9-89</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S202297



Part: 646.3311

Job No: 194914

Serial No/Batch: S202297

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/01/19

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130 QC 8	24 pcs	6/24/19	0.00 0.00	QC 2 - 66		
				QC 2 - 64		
				QC 2 - 65		
				QC 2 - 5		
				QC 2 - 71		
				QC 8 - 12		
				QC 8 - 14		
				QC 8 - 17		
				QC 8 - 20		
				QC 8 - 25		
				QC 8 - 3		
				QC 8 - 32		
				QC 8 - 33		
				QC 8 - 35		
				QC 8 - 39		
				QC 8 - 4		
				QC 8 - 44		
				QC 8 - 45		
				QC 8 - 49		
				QC 8 - 58		
				QC 8 - 8		
				QC 8 - 9		
				QC 8 - 68		
				QC 8 - 67		
				QC 8 - 1 (A)	14-08-06	
				QC 8 - 47		
				QC 8 - 40		
				QC 8 - 52		
				QC 8 - 23		
140 Outsource - 4 - Anodize	24 pcs	6/24/19		ATG001-VC	8	2019-08-06
150 Packaging 2-1 - Receive - B4B	24 pcs	6/24/19	0.00 0.00	Packaging 2 - 1 - B4B		AUG 12 2019
				Packaging 2 - 2 - B4B		
				Packaging 2 - 3 - B4B		
				Packaging 2 - 5 - B4B		
				Packaging 2 - 4 - B4B		
				Packaging 2 - 6 - B4B		
				Packaging 2 - 7 - B4B		
				Packaging 2 - 8 - B4B		
				Packaging 2 - 9 - B4B		
				Packaging 2 - 10 - B4B		
				Packaging 2 - 11 - B4B		
				Packaging 2 - 12 - B4B		
				Packaging 2 - 13 - B4B		
				Packaging 2 - 14 - B4B		
				Packaging 2 - 15 - B4B		
				Packaging 2 - 16 - B4B		
				Packaging 2 - 17 - B4B		
				Packaging 2 - 18 - B4B		
				Packaging 2 - 19 - B4B		
				Packaging 2 - 20 -		
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				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
155	QC 6	24 pcs	6/24/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
180	Packaging 3-1 - Stock - B4B	24 pcs	6/24/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
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					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	Pc CCK022
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA					24	6/24/19
					pcs	0.00 0.00
					QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB154
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 44211
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)

AUG 15 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S2.000X7.000	7075-T6S Sheet 2" Thick Plate X 7" Wide (Order In Billets - 13.375")	26.7600 ft (1.115 ea)	110-HAAS 4 Axis	5192518

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M7075T6S2.000X7.000	27	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	RH Half	7.296inches $\pm$ 0.005	7.301 7.291	7.296	
2	RH Half	3.767inches $\pm$ 0.005	3.772 3.762	3.768	
3	RH Half	0.457inches $\pm$ 0.005	0.462 0.452	0.457	
4	RH Half	0.313inches $\pm$ 0.005	0.318 0.308	0.313	
5	RH Half	0.710inches $\pm$ 0.005	0.715 0.705	0.710	
6	RH Half	6.469inches $\pm$ 0.005	6.474 6.464	6.468	
7	RH Half	10.116inches $\pm$ 0.005	10.121 10.111	10.115	
8	RH Half	10.309inches $\pm$ 0.005	10.314 10.304	10.307	
9	RH Half	0.177inches $\pm$ 0.005 - 0.001	0.182 0.176	0.177	diameter
10	RH Half	0.209inches $\pm$ 0.005 - 0.001	0.214 0.208	0.209	diameter
11	RH Half	0.250inches $\pm$ 0.005	0.255 0.245	0.252	
12	RH Half	1.250inches $\pm$ 0.005	1.255 1.245	1.252	
13	RH Half	0.125inches $\pm$ 0.005	0.130 0.120	0.125	Radius
14	RH Half	3.513inches $\pm$ 0.005	3.518 3.508	3.513	
15	RH Half	8.375inches $\pm$ 0.005	8.380 8.370	8.374	
16	RH Half	0.250inches $\pm$ 0.005	0.255 0.245	0.250	
17	RH Half	8.100Degrees $\pm$ 0.500	8.600 7.600	8.1°	Angle
18	RH Half	11.689inches $\pm$ 0.005	11.694 11.684	11.688	
19	RH Half	11.250inches $\pm$ 0.005	11.255 11.245	11.248	
20	RH Half	0.200inches $\pm$ 0.005	0.205 0.195	0.200	
21	RH Half	45.000Degrees $\pm$ 0.000	45.000 45.000	45°	Angle

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DAS
52
9-89

19/01/25

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044211



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044211

PO Date: 8/6/19

Due Date: 8/9/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-08-08

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196069	D5579-1	Center Clip, Cable Cutter : Various STC's Issue P/O: _____ 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5579 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	8/9/19	4 pcs	0 pcs	4 pcs	\$8.12/pcs	\$32.48
2	196070	D5580-1	Shim, Cable Cutter : Various STC's Issue P/O: _____ 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5580 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	8/9/19	4 pcs	0 pcs	4 pcs	\$8.12/pcs	\$32.48
3	194912	646.3310	LH Half - Upper Cutter Assembly : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 646.3300	Firmed	-	8/9/19	20 pcs	0 pcs	20 pcs	\$20.37/pcs	\$407.40

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PURCHASE ORDER

POHB044211



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	194914	646.3311	RH Half - Upper Cutter Assembly : Various STC's Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed	-	8/9/19	24 pcs	0 pcs	24 pcs	\$20.37/pcs	\$488.88
				24 X		AUG 12 2019				DAS 61 9-89	
5	197956	D5155-043	Co-Pilot Collective Head Assembly (212/412) : Various STC's Anodize Black as per Dwg D5155 Rev. B	Firmed	-	8/9/19	3 pcs	0 pcs	3 pcs	\$8.02/pcs	\$24.06
				3 X		AUG 09 2019					
Grand Total:											\$985.30

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/8/19 11:33 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918392

Date: 12-Aug-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 646.3310 ✓ LH Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25707 PO: POHB044211 ✓	Rev: A	Line: 3
24 ea	Part: 646.3311 ✓ RH Half Upper Cutter Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25708 PO: POHB044211 ✓	Rev: A	Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>12/8/19</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada. RECEIVED AUG 12 2019 DART AEROSPACE LTD. 6102 71 90V			